

BLAST MACHINE TROUBLESHOOTING GUIDE

This guide is designed to help you, as a blast machine operator, in identifying what problems you may face, and what steps to follow to get to the root of the problem.

When a problem arises, it should be looked at in a systematic and logical manner by:

1. Identifying the problem.
2. Gather all related (and seemingly unrelated) data (i.e.: check all equipment).
3. List all possible causes and solutions.
4. Weigh the options. What is the most likely cause/solution to the problem?
5. Select the most likely solution.
6. Act.
7. Did this solve the problem? If not, go back to your list of solutions and try the next best choice. Act again.
8. If you have exhausted all possibilities contact your supervisor.

Blast Machine Troubleshooting Solutions

Problem: Low amperage displayed on ammeter

- Check if low amperage is on one ammeter or more than one
- Was the abrasive level O.K. in the storage hopper at the start of the shift?
- Are all of the slide valves fully open at the bottom of the storage hopper?
- Call maintenance.

Problem: No abrasive getting to a wheel or a number of wheels

- Is the paint conveyor running?
- Is the abrasive switch on?
- Have parts passed through the sensor beams at the machine entrance?
- Has the proper bar code been applied?
- Was the abrasive level O.K. in the storage hopper at the start of the shift?
- Are all of the slide valves fully open at the bottom of the storage hopper?
- Are all of the rubber feed hoses in place at the feed spouts for each wheel?

- If not, call your supervisor

Problem: Storage hopper level is low/empty/peak not “centered”

- Call your supervisor.

Problem: Poor cleaning

- Check condition of the parts before cleaning
- Has the correct program been selected?
- Has the proper bar code been applied?
- Is the amperage correct for the program selected?
- Is the paint conveyor speed correct?
- Call your supervisor.

Problem: Abrasive in dust collector (dust bins)

- Call maintenance.

Problem: Abrasive in dust pails

- Check for obstructions at the swinging baffle
- Call your supervisor.

Problem: Dust in storage hopper

- Call your supervisor.

Problem: Stalled or jammed elevator

- Call your supervisor.

Problem: Stalled or jammed screw conveyor

- Call your supervisor.

Problem: Swinging baffle sticking

- Check for debris causing swinging baffle to stick
- Call your supervisor.
- Record this occurrence on the daily log sheet

Problem: Abrasive flowing through refuse pipe, onto the floor

- Emergency stop machine
- Check for debris causing swinging baffle to stick
- Call your supervisor.
- Record this occurrence on the daily log sheet

Problem: Machine won't start up

- Is the main power on?
- Has the machine stop switch been pressed to reset any alarm?
- Check the panel for alarm indicating lights
- Call Electrical Maintenance

Problem: Machine shuts down "for no reason"

- Check the panel for alarm indicating lights
- Attempt to restart the machine
- Call Electrical Maintenance
- Record this occurrence on the daily log sheet

Problem: Excessive dust coming out of flaps

- Check the differential pressure for the main and final filters
- Call your supervisor.

Problem: Shot adder not working

- Is there abrasive in the adder hopper?
- Is the air supply on?
- Is the adder valve jammed?
- Is the adder opening restricted with debris?
- **DO NOT PLACE YOUR HANDS OR FINGERS NEAR THE VALVE IF THE MACHINE POWER IS ON!**
- Call your supervisor.
- Record this occurrence on the daily log sheet

Problem: Contaminants in abrasive

- Call your supervisor.

Problem: Excessive wear of cabinet or internal parts

- Call your supervisor.

Problem: Excessive abrasive consumption

- Call your supervisor.

Problem: Unusual noises, odours, or vibrations

- Call your supervisor.
- Record this occurrence on the daily log sheet

Note: If a problem has occurred and you have been unable to solve it by using this Troubleshooting Guide, call your supervisor. Maintenance. DO NOT attempt to repair the machine by yourself. Any problems, unusual noises, odors or vibrations must be recorded on the daily log sheet.